

Work Order ID 62748

Page 1

Thursday, October 07, 2010 3:08:51 PM

Item ID: D206-628-023

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step LH

Stop



Start Date: 10/7/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: *MM*

Date: 10-10-07

Tooling:

Date: _____

Run Start



QC:

Date: _____

SPC (Y/N):

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr

100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

0.00

8/10/10 / *10/10/10* *10/11/10* *10/11/10* (4)
MM *10/10/10* *10/11/10* *10/11/10* *10/11/10* (4)
MM *10/10/10* *10/11/10* *10/11/10* *10/11/10* *10/11/10* (4)

110



Pick Kit

0.00

Packaging

Packaging

Memo

0.00

10/11/12 *10/11/12* *10/11/12* (4)

120



QC4- 100% Inspect kits for completeness

0.00

QC

Quality Control

Memo

0.00

8/10/10

/ *10/10/10* *10/11/10* *10/11/10* *10/11/10* (4)
10/11/10 *10/11/10* *10/11/10* *10/11/10* *10/11/10* (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D206-628-023

Accept



Setup

Start



Revision ID:

Item Name: Heli-Access-Step LH

Stop



Start Date: 10/7/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Packaging

Operation
Description

Packaging

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/11/16 JH

*CMF**10-11-16*

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 62748



Parent Item: D206-628-023



Parent Item Name: Heli-Access-Step LH

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D As Per Ecn766 06-01-06 JLM
IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC
IPP rev F ncr 09-004 09.01.09 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A  BOLT		Purchased	No			120	Each	1,650.000	3	12		10/11/10 SP	

Location	Loc Qty	Loc Code
ST245	20	
110139	20	
ST303	42	
115438	42	
ST350	1588	
114108	14	
114416	12	
114523	2	
115300	560	
115589	1000	

AN4C14A  Bolt	Purchased	No			120	Each	87.0000	4	16	10/11/10 SP (40)		
---	-----------	----	--	--	-----	------	---------	---	----	------------------	--	--

Location	Loc Qty	Loc Code
ST358	87	
111902	17	
115767	40	
115835	30	

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Work Order ID: 62748



Parent Item: D206-628-023



Parent Item Name: Heli-Access-Step LH

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

AN4C15A

Purchased

No

120

Each

127.0000

8

32

10/11/10 sf

Bolt

Location	Loc Qty	Loc Code
ST358	127	
114442	1	
115457	26	
115835	100	

AN960C10

NAS1149C0363 Purchased

No

120

Each

0.0000

3

12

M113644 10/11/10 sf
M114742 10/11/10 sf

WASHER

AN960C416L

Purchased

No NAS1149C0432R

120

Each

180.0000

24

96

WASHER

Location	Loc Qty	Loc Code
FG	44	
104925	44	
ST346	136	
106785	10	
107008	10	
112828	75	
69220	41	

D2731-7

Manufactured

No

120

Each

39.0000

4

16 8x5
B62230 B62402C

Mounting Lug

Location	Loc Qty	Loc Code
ST420	15	
60996	15	
ST470	24	
61653	24	

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 62748



Parent Item: D206-628-023



Parent Item Name: Heli-Access-Step LH

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

D2732

Manufactured No

120

f

216.4157

2

8



10/11/12 8

Rubber Extrusion

Location	Loc Qty	Loc Code
ST412	216.415737	
43118	2.5	
56516	213.915737	

(D2732-030) Cut (8) at 3.00"

D2842-041

Manufactured No

120

Each

2.0000

1



10/11/12 8

Step Assembly, 206 Float

Location	Loc Qty	Loc Code
ST	2	
61045	2	

D2844-1

Manufactured No

120

Each

1.0000

2



10/11/12 8

Arm

Location	Loc Qty	Loc Code
ST265	1	
52030	1	

D2844-3

Manufactured No

120

Each

9.0000

1



10/11/12 8

Arm

Location	Loc Qty	Loc Code
ST265	9	
61453	9	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 62748



Parent Item: D206-628-023



Parent Item Name: Heli-Access-Step LH

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

D3394-043

Manufactured

No

120

Each

49.0000

4

16

102



B62667 10/11/2010

Lug Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST420	19	
-------	----	--

60997	19	
-------	----	--

ST475	30	
-------	----	--

62005	30	
-------	----	--

ST420	19	
-------	----	--

60997	19	
-------	----	--

ST475	30	
-------	----	--

62005	30	
-------	----	--

ST420	19	
-------	----	--

60997	19	
-------	----	--

ST475	30	
-------	----	--

62005	30	
-------	----	--

ST420	19	
-------	----	--

60997	19	
-------	----	--

ST475	30	
-------	----	--

62005	30	
-------	----	--

ST420	19	
-------	----	--

60997	19	
-------	----	--

ST475	30	
-------	----	--

62005	30	
-------	----	--

ST420	19	
-------	----	--

60997	19	
-------	----	--

ST475	30	
-------	----	--

62005	30	
-------	----	--

ST420	19	
-------	----	--

60997	19	
-------	----	--

ST475	30	
-------	----	--

62005	30	
-------	----	--

ST420	19	
-------	----	--

60997	19	
-------	----	--

ST475	30	
-------	----	--

62005	30	
-------	----	--

ST420	19	
-------	----	--

60997	19	
-------	----	--

ST475	30	
-------	----	--

62005	30	
-------	----	--

NAS151SH3

Purchased

No

120

Each

98.0000

3

12



10/11/12 SH4

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST277	98	
-------	----	--

111268	4	
--------	---	--

ST277	94	
-------	----	--

115675	94	
--------	----	--

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	:						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Thursday, October 07, 2010 3:08:55 PM

Work Order ID: 62748



Parent Item: D206-628-023



Parent Item Name: Heli-Access-Step LH

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

NAS1515H4L



Purchased No

120 Each

456.0000

24

96



10/11/10

SP4c

WASHER

X4

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	40	
103691	40	
ST277	416	
112492	11	
114236	48	
114265	357	

90

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

S

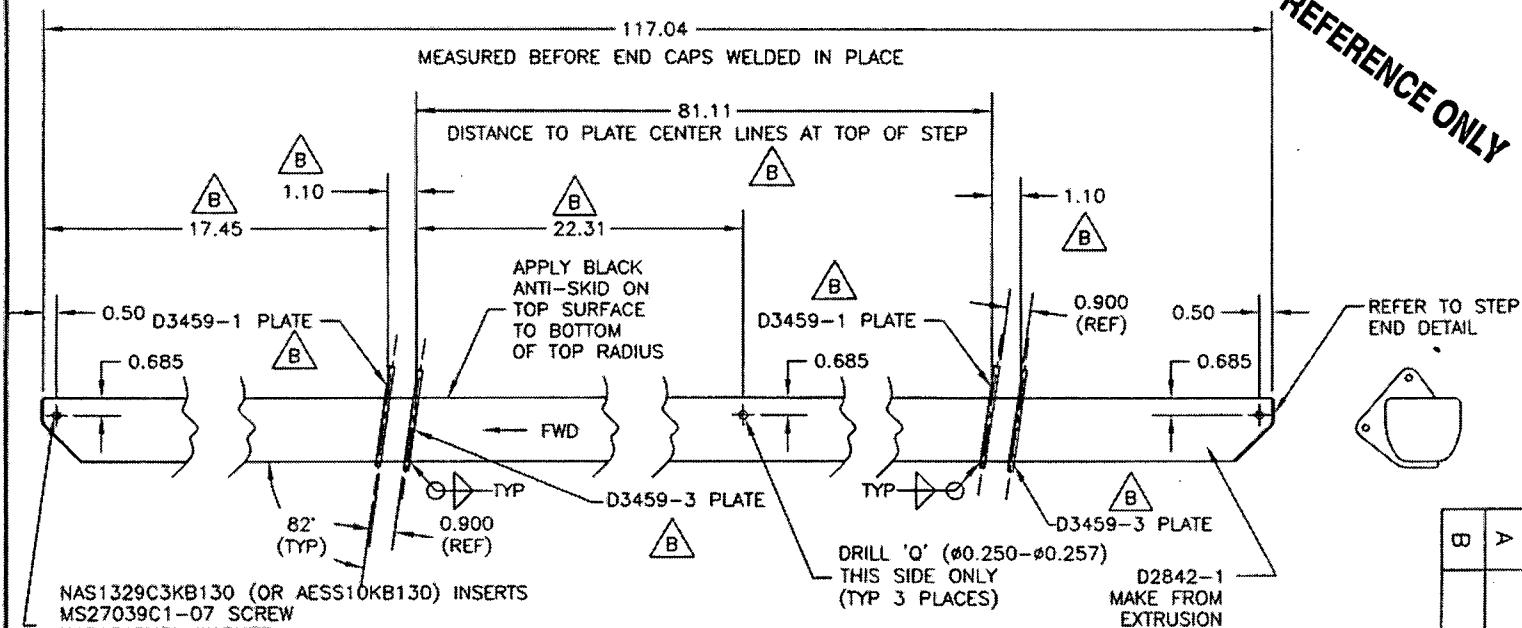
5.2 D206-628-013/-014/-023/-024/-033/-033 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1						D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
		1	1	1	1	D2844-3	ARM
2	2					D2845	ARM
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	AN960C10	WASHER
24	24	24	24	24	24	AN960C416L	WASHER
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	NUT
2	2	3	3	3	3	NAS1515H3	WASHER

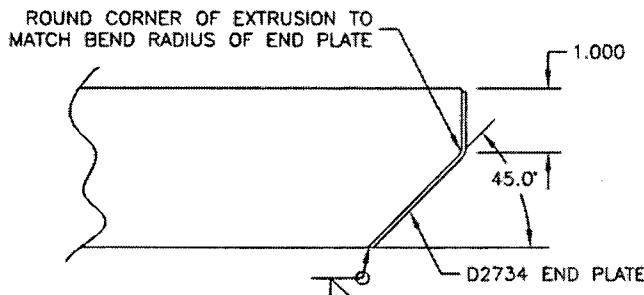
*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

DART

REFERENCE ONLY

**D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST**

QTY .041	QTY .042	PART NUMBER	DESCRIPTION
X	X	D2842-041	LH STEP ASSEMBLY
		D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05/14

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DESIGN KE	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. B
CHECKED	APPROVED	DRAWING NO.	SCALE
<i>H</i>	<i>H</i>	D2842	
05.09.23		206L/407 FLOAT STEP ASSEMBLY	SHEET 1 OF 1
A	98.10.13	NEW ISSUE	
B	05.09.23	RE-DESIGN, ADD D3459-1/-3	